

B.) Please amend the claims as follows:

1. (Twice amended) A method for contouring a workpiece for the manufacture of an automotive instrument panel support beam, said method including the steps of:

selecting a starting metal blank tube having a uniform wall thickness along the length thereof and a constant outside dimension diameter substantially the same outside dimension diameter as desired for producing a drivers side support beam portion comprised of a first constituent of length of said starting metal blank in a workpiece for the manufacture of an automotive instrument panel support beam;

reducing the cross sectional size of an end portion of said starting metal blank remote to said drivers side support beam portion;

operating a gripper to engage said end portion produced by said step of reducing; and

producing a passenger side support beam portion by using said gripper for drawing said starting metal blank tube only partly through a contoured die or only partly through each one of a succession of contoured dies to reduce the outside dimension outer diameter essentially only along a part of said starting metal blank tube remaining between said driver side support beam portion and said end portion without producing an appreciable increase to said uniform wall thickness for producing a second constituent of length in said workpiece for the manufacture of an automotive instrument panel support beam.

2. (Currently amended) The method according to claim 1 wherein said step of producing a passenger side support beam portion drawing includes using tension only to apply contact pressure on said contoured die or said contoured dies by

said starting metal blank tube to maintain essentially the same wall thickness along the reduced outer dimension diameter of said starting metal blank tubular work-piece along said second constituent of length.

3. (Currently amended) The method according to claim 1 including the further step of working the metal wall of said starting metal blank tube concurrently with said step of producing a passenger side support beam portion drawing to form said second constituent of length in said starting metal blank workpiece for manufacture of an automotive instrument panel support beam.

4. (Currently amended) The method according to claim 3 wherein said step of working the metal wall of said starting metal blank tube includes contacting an internal wall section of said starting metal tube confronting said contoured die or said contoured dies with a mandrel concurrently with using tension to apply contact pressure on said contoured die or said contoured dies to both reduce the wall thickness and reduce said constant outside dimension the outer diameter along said second constituent of length in said starting metal blank workpiece for manufacture of an automotive instrument panel support beam.

5. (Currently amended) The method according to claim 3 wherein said step of contacting an internal wall section of said tubular work-piece includes seating a mandrel into the inside diameter at a pointed end of said starting metal blank tubular work-piece to a site confronting said contoured die or said contoured dies.

6. (Currently amended) The method according to claim 1 wherein a constituent length of said starting metal blank tube residing in said contoured die or contoured dies produces a tapering outside dimension diameter ranging between said first constituent of length and said second constituent of length in said starting metal

blank workpiece for the manufacture of an automotive instrument panel support beam.

7. (Currently amended) The method according to claim 1 including the further step of cutting an increment of length essentially comprising said end portion from an at least one end of said starting metal blank tube to define a desired aggregate length of a said workpiece for the manufacture of an automotive instrument panel support beam.

8. (Currently amended) The method according to claim 1 wherein said step of reducing the cross sectional size of an end portion includes including the further step of forming a push pointed end segment on said starting metal blank tube for establishing a desired outside dimension diameter for said step of producing a passenger side support beam portion drawing said starting metal tube.

9. (Currently amended) The method according to claim 8 including the further step of severing said push pointed end from said starting metal blank tube following said step of producing a passenger side support beam portion drawing said starting metal tube.

10. (Cancelled)

11. (Cancelled)

12. (Cancelled)

13. (Currently amended) The method of according to claim 1 wherein said step of producing a passenger side support beam portion includes using said contoured die or a succession of contoured dies to form a conical transition is further defined by an included angle within the range of 20 to 30 degrees.

14. (Original) The method of according to claim 13 wherein said included angle is in the range of 22 to 24 degrees.

15. (Twice amended) The method of according to claim 1 wherein said starting metal blank tube is a welded steel.

16. (Twice amended) The method of according to claim 1 wherein said starting metal blank tube is round.

17. (Twice amended) The method of according to claim 1 wherein said starting metal blank tube is rectangular.

18. (Twice amended) The method of according to claim 1 wherein said step of producing a passenger side support beam portion includes including the step of using said contoured die or a succession of contoured dies to form two spaced apart conical transitions between said first constituent of length and said second constituent of length lengths in said workpiece.

19. (Currently amended) The method of according to claim 18 wherein said step of producing a passenger side support beam portion includes using said contoured die or a succession of contoured dies to form two conical transitions is further defined by an included angle within the range of 20 to 30 degrees.

20. (Original) The method of according to claim 19 wherein said included angle is in the range of 22 to 24 degrees.

21. (Currently amended) A method for contouring a workpiece for an article of manufacture, the method including the steps of:

selecting a starting metal blank tube having a uniform wall thickness along the length thereof and a constant outside dimension diameter substantially the same

outside dimension diameter as desired for producing a first constituent of length desired for a the contoured workpiece, and

reducing the cross sectional size of an end portion of said starting metal blank remote to said first constituent of length:

operating a gripper to engage said end portion produced by said step of reducing:

drawing said starting metal blank tube only partly through a contoured die or only partly through each one of a succession of contoured dies to reduce the outside dimension diameter outer diameter essentially only along a part of said starting metal tube without producing an appreciable increase to the uniform wall thickness for producing a desired outside dimension diameter along a second constituent length desired for said the contoured workpiece;

working the metal of said starting metal blank concurrently with said step of drawing to form said second constituent of length in said starting metal blank; and

cutting an increment of length essentially comprised of said end portion from said starting metal blank to define a desired aggregate length for said contoured workpiece.